



7337

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RBW6205G15231-3G

Job Sheet 187637



Part No: RBW6205G15231-3G

Job Qty: 1 ea

Part Name: AW139 Swashplate Box 1



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/10/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G15231-3G REV 1 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	1 pcs	1/11/19	1/11/19	0.00	0.00	Small Fab-4		MLC DAS
120	QC	1 pcs	1/11/19	1/11/19	0.00	0.00	QC5		DAS 38
130	Packaging	1 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-1		28 9-89
140	QC21-FG	1 Ea	1/11/19	1/11/19	0.00	0.00	QC21		9-89

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican Strom
Descriptions: case IM-2875-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6205G15231-3G-9 to RBW6205G15231-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90183A213	BLIND RIVET FLAT WASHER ALUMINUM, ROUND, FOR 1/8" RIVET BODY DIA., 3/8" OD	4 Ea (4 ea)	90-Start up Operation	
4611T26	Cup	2 Ea (2 ea)	110-Small Fab	3058755
97447A130	Aluminum Blind Rivet W/Aluminum Mandrel Domed, 1/8" Dia., 0.313"-0.375" Material Thickness	4 Ea (4 ea)	110-Small Fab	3054270
AN5-10A	Bolt	8 Ea (8 ea)	110-Small Fab	3054330
AN5-27A	Bolt 5/16 X 2 31/32 Steel	4 Ea (4 ea)	110-Small Fab	F122800
AN960-516	WASHER SEE PART NAS1149F0563P	8 pcs (8 ea)	110-Small Fab	3011347
IM2875-E	Pelican Case	1 Ea (1 ea)	110-Small Fab	3098034
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	3077839
RBW6205G11451-3G	Clamp	1 Ea (1 ea)	110-Small Fab	3021040
RBW6205G11651-3G	Guide	8 Ea (8 ea)	110-Small Fab	3134657
RBW6205G11751-3G	Guide	1 Ea (1 ea)	110-Small Fab	3058321
RBW6205G15231-3G-5	Bottom Foam use in case IM2875-E	1 Ea (1 ea)	110-Small Fab	3134650
RBW6205G15231-3G-7	Lid Foam use in case IM2875-E	1 Ea (1 ea)	110-Small Fab	3077821
RBW6205G15231-3G-9	Inside Placard	1 Ea (1 ea)	110-Small Fab	3077822
RBW6205G15551-3G	Pin	1 Ea (1 ea)	110-Small Fab	3138315
				3062836

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90183A213	4	488	0
110-Small Fab	4611T26	2	6	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

97447A130	4	235	0
AN5-10A	8	286	0
AN5-27A	4	18	0
AN960-516	8	274	0
IM2875-E	1	4	0
RB41011	1	676	0
RBW6205G11451-3G	8	24	0
RBW6205G11651-3G	1	4	0
RBW6205G11751-3G	1	7	0
RBW6205G15231-3G-5 -	1	4	0
RBW6205G15231-3G-7 -	1	4	0
RBW6205G15231-3G-9	1	1	0
RBW6205G15551-3G	1	2	0

Part Specifications

Specifications could not be found.

Plex 12/10/18 3:03 PM Dart.lajeunesse.marie



Container No: S142327



Part: RBW6205G15231-3G

Job No: 187637

Serial No/Batch: S142327

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.

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CANADA

TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/07/19

45 min

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

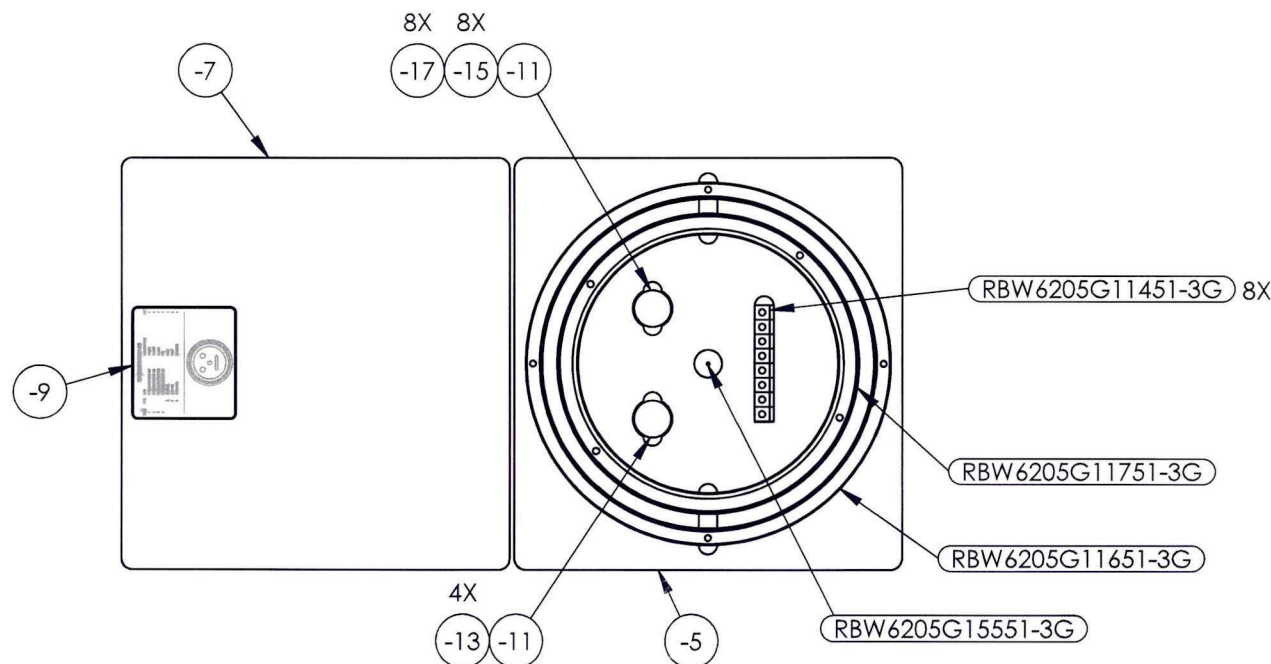
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-5 ADDED FINGER CUTOUTS. -7 CH'D PLACARD CUTOUT TO RECESSED, CH'D MATERIAL WAS EGGSHELL IS C200 FLAT.	5/24/2011	RJC	RW
1	15-0175	-7 CH'D MATERIAL WAS C200 FLAT IS Y20 BLACK. -9 DELETED CONTENT LIST FROM PLACARD. -19, -21, & -23 ADDED TO BOM.	7/17/2015	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187637 M.C.
18-12-10

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	GUIDE		RBW6205G11651-3G	1
				8	CLAMP		RBW6205G11451-3G	1
				1	GUIDE		RBW6205G11751-3G	1
				1	PIN	W1 TOOL STEEL	RBW6205G15551-3G	1
		B/O	-3	1	CASE	PLASTIC, BLACK	11.40 X 21.10 X 22.50 PELICAN STORM IM2875-E	N/S
		B/O	-5	1	BOTTOM FOAM	Y20 BLACK	9-1/2 X 21 X 22-1/2 IR SPECIALTY FOAM	2
		B/O	-7	1	LID FOAM	Y20 BLACK	2 X 21 X 22-1/2 IR SPECIALTY FOAM	3
			-9	1	INSIDE PLACARD	PLASTIC		4
		B/O	-11	2	CUP	CLEAR PLOYSTYRENE	Ø1.77 X 4.02 (MCMaster-CARR #4611T26)	1
		B/O	-13	4	BOLT	STEEL	AN5-27A	1
		B/O	-15	8	BOLT	STEEL	AN5-10A	1
		B/O	-17	8	WASHER	ALUMINUM	AN960-516	NS
		B/O	-19	1	DART PLACARD	ALUMINUM	#RB41011	N/S
		B/O	-21	4	RIVET	ALUMINUM	Ø1/8 X .525 (MCMaster-CARR #97447A130)	N/S
		B/O	-23	4	BLIND RIVET WASHER	ALUMINUM	Ø1/8 (MCMaster-CARR #90183A213)	N/S

NOTE:

REF. AGUSTA T/N: 3G6205G15231.
PART OF KIT RBW6205G11231-3G.

DART AEROSPACE	
TITLE AW139 SWASHPLATE KIT	
DWG NO. RBW6205G15231-3G	
REV 1	
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: CLOUGH APPROVED D Weil HEAT TREAT FINISH SPEC USED ON MODEL AGUSTA
SCALE 1:10	DATE 1/31/2011
SHEET 1 OF 4	